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**2-1/4" Pro 3.1 Kit Instructions  
 Big Block Chevrolet**

This header kit was prototyped on a Big Block Chev engine installed in a Chris Alston Chassisworks Elimator with a-arm front suspension by a customer, Todd Fix. It is designed to go out over the frame rails and then come back underneath so the collectors end up between the frame rails. The pipes are numbered for BB Chevy cylinders. The kit was bent intending to have material removed from the flange end of each tube.

The following recommendation is intended as a guideline only. DO NOT accept it as the gospel and then call us and say "I cut off the amount you told me and now I find I cut off too much because I followed your instruction." When modifying tubes use care, caution, and judgement. If you have to cut off tubing we suggest going in no more than 1" increments until you are sure you have the correct offset and then tack the whole header together.

Cylinder	Cut from A (flange) end	Cut/Remove & Weld
#1A	4-1/4"	3-1/2" of straight after bend
#1B (use as is)		
#3 (use as is)	3-1/2"	
#5	4"	2-1/2" of straight after 1st
bend		
		1" of straight after 3rd bend
#7A	4-1/4"	3-1/2" of straight after bend
#7B		3-3/4" of straight after 2nd
		bend of 7B (which is the 3rd
		bend of tube #7)
#2	4"	Cut after 2nd bend, rotate
		clockwise approx 30°
		Cut after 3rd bend and rotate
		clockwise approx 60°
#4	1-1/4"	Cut after 1st bend and rotate
		clockwise approx 110°
#6A	4"	1/2" straight after 2nd bend
#6B (use as is)		3-3/4" straight after bend
#8	4"	3-1/2" straight after 1st bend
		3-3/4" straight after 3rd bend
		(rotate clockwise 135° and
		reweld)

The left grouping should be:      7 1      Right grouping:      2 8  
    5 3                                      4 6

When installing tubes in the flange, it is advisable to angle grind flanges at cylinder #1, #7, #2.

Primary tube lengths are basically determined by the RPM range in which the engine will operate. Basically the following chart will get you in the ball park.

Primary tube length	Max engine RPM range
32"	7000 to 8000
30"	8000 to 8500
28"	8500 to 9000
26"	9000 to 9500

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